

Work Order ID 56242

Wednesday, February 17, 2010 10:07:06 AM



Page 1

Item ID: D206-558-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Single Cargo Mirror Assembly

Start Date: 2/18/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 3/3/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: mf Date: 10-2-17 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D206-558	Rev C								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D206-558-041 CHG008

8/10/04/22

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D206-558

8/10/03/31 (4)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/03/31

(x4)

10.03.17 (125) (perm change)

Pick kit

8/04/18 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Revision ID:

Stop



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Start Date: 2/18/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 3/3/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Solarte



140



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D206-558-041

Location: PPP Rev:

10/4/22 (4)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/22

YMF

10-4-22

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Parent Item Name: Single Cargo Mirror Assembly

Comments: IPP F02.09.19 Re-format; Incorporated D2065 KJ
IPP Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD
verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Date: 2/18/2010

Required Date: 3/3/2010

Start Qty: 4.00

Required Qty: 4.00

AN3-4A

Purchased No

Each 1,949.000 16.0000



Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	1949
104214	422
104291	300
104322	200
104374	200
104625	300
104817	527

AN526-1032R9

Purchased No

Each 139.0000 16.0000



Screw

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	39
101189	6
110584	5
111758	28

Main Warehouse

ST328	100
113928	100

AN960JD10

Purchased No

Each 0.0000 16.0000



Washer

QSI017

NAS1149D03631

M113288

(16X)

10/03/31

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verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

AN960JD10L

16

Purchased

No

(125) M

Each

3,457.000

24.0000



Washer

10/4/22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3457

101291

16

105793

49

110985

3392

(110) M

116985

D2011-101

Manufactured

No

Each

8.0000

4.0000



6" Mirror

9/5/10/03/31

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8

53992

8

(110) M

Each

9.0000

8.0000

356795 (4x)

D2052

Manufactured

No



Mounting Bracket

9/5/10/03/31

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST005

9

39556

5

47596

4

B56290 (34)

4
1

Wednesday, February 17, 2010 10:07:06 AM

Shop Packet Print

Page 2

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 verified:ec
 IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Date: 2/18/2010

Required Date: 3/3/2010

Start Qty: 4.00

Required Qty: 4.00

D2058
 Mounting Bracket

Manufactured No

Each

19.0000

4.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST005

19

47595

19

Each

7.0000

8.0000

D2054
 Bushing

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST005

7

53179

7

Each

15.0000

4.0000

D2055
 Clamp

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST005

15

55726

15

Dart Aerospace Ltd

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verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

D2056 / Manufactured No (110) M Each 4.0000 4.0000
Bell Crank

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST006

4

55598

4

Manufactured No

(110) M

Each

63.0000

4.0000

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST006

63

34366

42

40048

21

Manufactured No

(110) M

Each

6.0000

4.0000

Warehouse Loc Qty Loc Code
Location

Main Warehouse

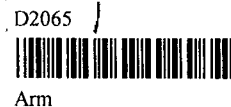
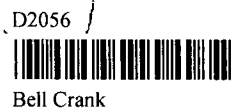
ST

6

41524

6

D2065 /
Arm



EP 10/03/31
356302 (2X)

2
EP 10/03/31
357039 (4X)

EP 10/03/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Date: 2/18/2010

Required Date: 3/3/2010

Start Qty: 4.00

Required Qty: 4.00

D2067 Connector

Manufactured No

Each 32.0000 4.0000

Connector

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST6

32

54698

32

Manufactured No

Each

7.0000

4.0000

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

7

54777

7

Manufactured No

Each

5.0000

4.0000

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

5

45576

5

D2071 Cable Assembly

Manufactured No

Each 7.0000 4.0000

Cable Assembly

54698

32

32

7.0000

4.0000

54698

32

32

7.0000

4.0000

D3778-1 Bracket

Manufactured No

Each 5.0000 4.0000

Bracket

54777

7

7

5.0000

4.0000

54777

7

7

5.0000

4.0000

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 verified:ec
 IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

MS 2004213

Purchased

No



Each

2,665.000

4.0000



Nut

Per 4/8 (Y)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2659

110844

35

111274

27

111668

52

112314

289

112385

498

113523

58

113537

700

113644

1000

M113537

Main Warehouse

ST139

6

111668

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Wednesday, February 17, 2010 10:07:06 AM

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Required Date: 3/3/2010

Comments: IPP F02.09.19 Re-format; Incorporated D2065 KJ
IPP Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD
verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

(110) DA

Each

2,665.000

8.0000



Nut



8/510/03/31

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2659

110844

35

111274

27

111668

52

112314

289

112385

498

113523

58

113537

700

113644

1000

Main Warehouse

ST139

6

111668

6

MS21919-DG5

x2

Purchased

No

(125) DA

Each

41.0000

8.0000



Clamp



11/4/8 (4)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

110916

41

114348 x4
1110916 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 verified:ec
 IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-18

Purchased

No

110

Each

112.0000

8.0000



Screw



8/5/10/03/31

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112

110916

12

113845

100

7
1

MS35489-9

Purchased

No

Each

104.0000

4.0000



Grommet



6/14/18 (4)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

104

107376

24

109371

80

1107376

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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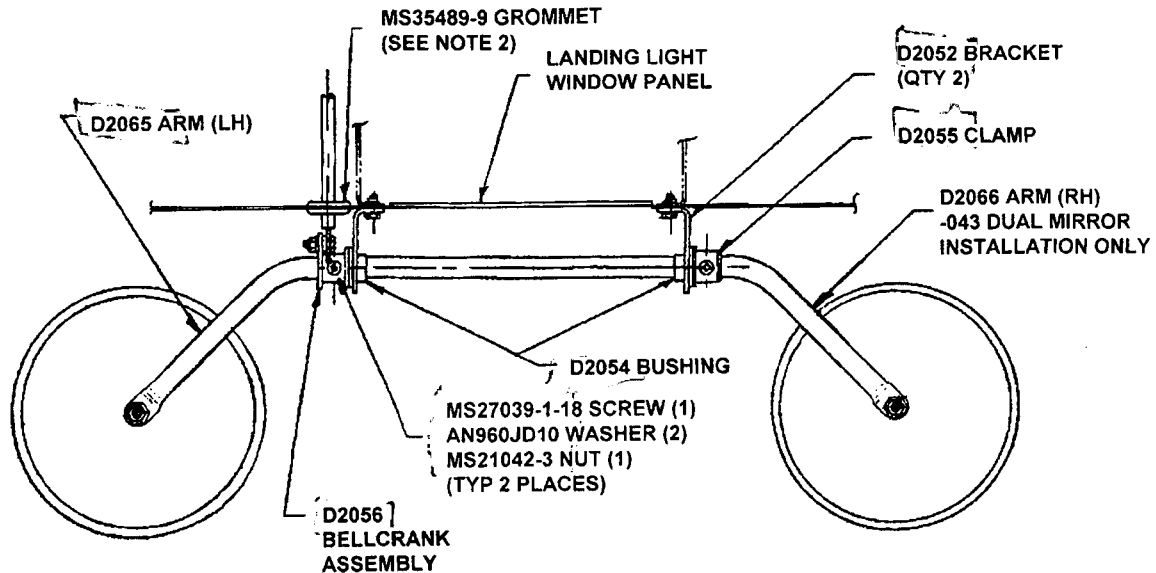


Figure 25.2 - View A: Looking Aft.
(D206-558-043 Mirror Shown)

#56242

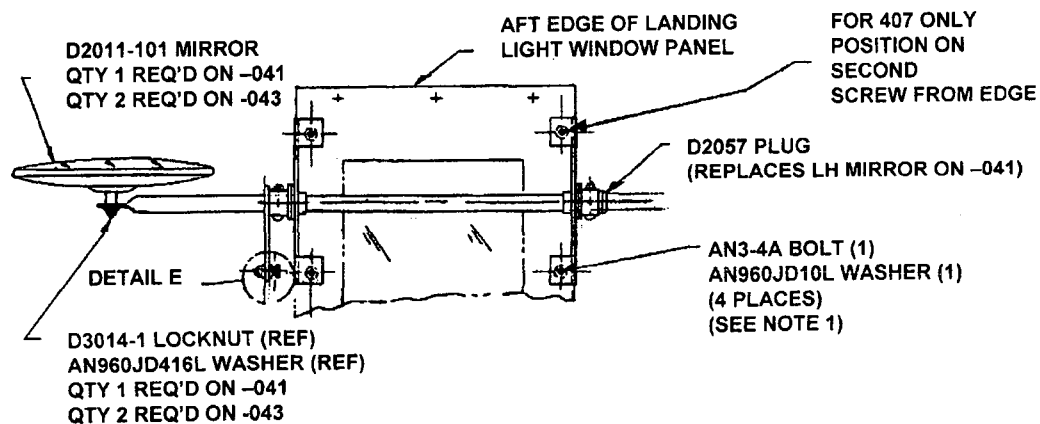


Figure 25.3 - View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

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Dart Aerospace Ltd

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NOTE: Date & initial all entries

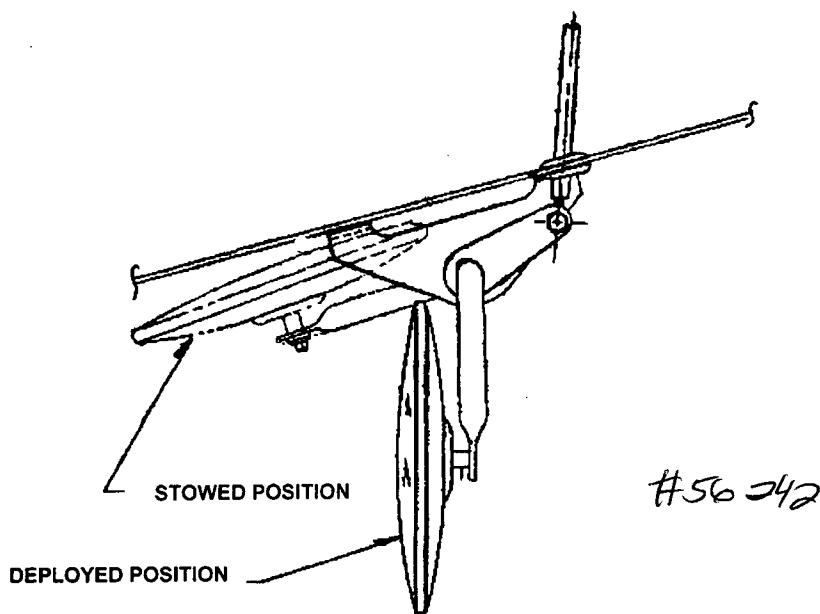


Figure 25.4 – Detail D: Looking from Side on Mirror Installation
(D206-558-041/-043 Mirror Shown)

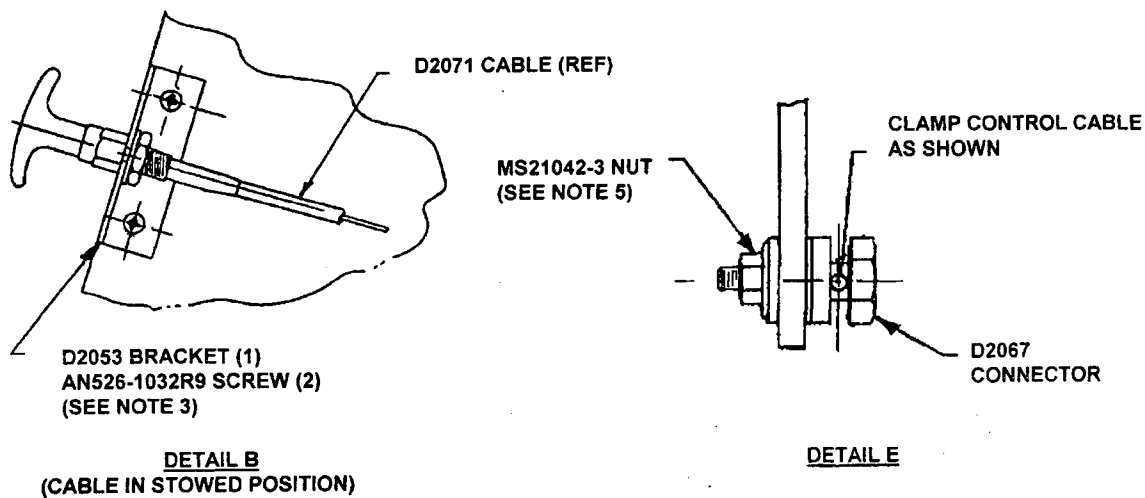


Figure 25.5 – Details B and E on Mirror Installation
(D206-558-041/-043 Mirror Shown)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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ICA-D206-558

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25.2 CARGO MIRROR REMOVAL

1. Loosen MS21042-3 nut and remove D2071 control cable from D2067 connector.
2. Remove (4) AN3-4A bolts and remove D2052 bracket.
3. Remove (2) AN526-1032R9 screws and (2) MS21919DG5 clamps.
4. Remove (2) AN526-1032R9 screws, the D2053 bracket and the D2071 cable assembly.

25.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 206A/B/L/L1/L3/L4	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
Bell 407					
D206-558-043	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 206A/B/L/L1/L3/L4	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg
Bell 407					

25.4 PARTS LIST

Qty -041	Qty -043	Part Number	Description
X		D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X	D206-558-043	DUAL CARGO MIRROR ASSEMBLY
1	2	D3014-1	* LOCKNUT
1	1	D2071	CABLE ASSEMBLY
2	2	D2054	BUSHING
1	1	D2067	CONNECTOR
	1	D2066	ARM
1		D2065	ARM
1		D2057	PLUG
1	1	D2056	BELLCRANK ASSEMBLY
1	1	D2055	CLAMP
1	1	D2053	BRACKET
2	2	D2052	BRACKET
1	2	D2011-101	MIRROR ASSEMBLY
4	4	AN3-4A	BOLT
4	4	AN526-1032R9	SCREW
1	2	AN960JD416L	* WASHER
4	4	AN960JD10	WASHER
6	6	AN960JD10L	WASHER
3	3	MS21042-3	NUT (or MS21042L3)
2	2	MS21919DG5	CLAMP
2	2	MS27039-1-18	SCREW
1	1	MS35489-9	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

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25-00-00

Revision: 0

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NOTE: Date & initial all entries

REFERENCE ONLY 5

FROM THIS POINT FORWARD, CUSTOMERS SHOULD ORDER D407-558-045/-047 IN LIEU OF D206-558-041/-043 WHEN PROCURING SINGLE/DUAL MIRRORS FOR BHT 407 MODELS. AMEND SECTIONS 4.0 AND 5.0 OF INSTALLATION INSTRUCTIONS D206-558 REV. C OR EARLIER AND 25.3 AND 25.4 OF ICA-D206-558 REV. 0 AS FOLLOWS:

4.0 WEIGHT AND BALANCE (D206-558 REV. C OR EARLIER)

25.3 WEIGHT AND BALANCE (ICA-D206-558 REV. 0)

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 206A/B/L/L1/L3/L4	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D206-558-043	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 206A/B/L/L1/L3/L4	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg
D407-558-045	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 407	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D407-558-047	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 407	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg

5.0 PARTS LIST (D206-558 REV. C OR EARLIER)

25.4 PARTS LIST (ICA-D206-558 REV. 0)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X			D206-558-043	DUAL CARGO MIRROR ASSEMBLY
		X		D407-558-045	SINGLE CARGO MIRROR ASSEMBLY
			X	D407-558-047	DUAL CARGO MIRROR ASSEMBLY
1	2	1	2	D2011-101	MIRROR ASSEMBLY
2	2	2	2	D2052	BRACKET
1	1	1	1	D2053	BRACKET
2	2	2	2	D2054	BUSHING
4	1	1	1	D2055	CLAMP
4	1	1	1	D2056	BELLCRANK ASSEMBLY
4		1		D2057	PLUG
4		1		D2065	ARM
	1		1	D2066	ARM
1	1	1	1	D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	1	D2071-3	CABLE ASSEMBLY
1	2	1	2	D3014-1	* LOCKNUT
1	1	1	1	D3778-1	BRACKET
4	4	4	4	AN3-4A	BOLT
4	4	4	4	AN526-1032R9	SCREW
4	2	1	2	AN960JD416L	* WASHER
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD10L	WASHER
3	3	3	3	MS21042-3	NUT (or MS21042L3)
2	2	2	2	MS21919DG5	CLAMP
2	2	2	2	MS27039-1-18	SCREW
1	1			MS35489-9	GROMMET
		1	1	MS35489-67	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.12.04
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9436	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CABLE CHANGE	NTS
DATE	08.12.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries